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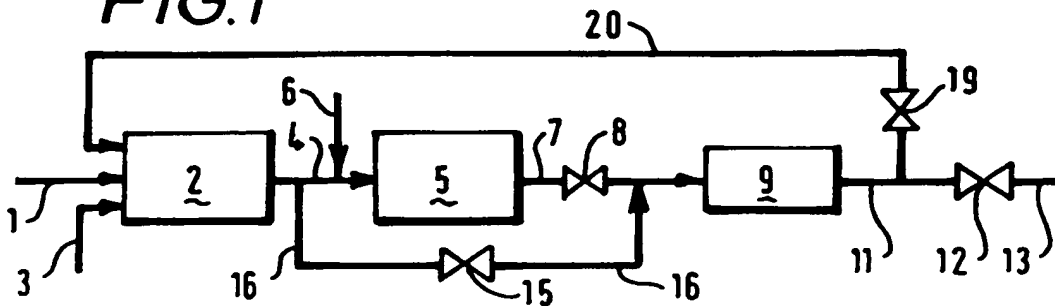
**0 661 375 A1**

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NL-3813 MS Amersfoort (NL)**(54) **Process for removing nitrogen compounds from synthesis gas.**

(57) A process of removing hydrogen cyanide and ammonia from synthesis gas obtained from partially oxidizing in a gasification reactor (2) a feed selected from the group including coal, oil or natural gas comprising supplying the synthesis gas in the presence of water to a reactor (5) containing hydrolysis catalyst; contacting the synthesis gas having an increased ammonia content from the reactor (5) in a sorption vessel (9) with regenerable sorption material to obtain ammonia-loaded sorption material and

treated synthesis gas having a reduced content of nitrogen compounds, and withdrawing treated synthesis gas from the sorption vessel (9); and regenerating loaded sorption material to produce regenerated sorption material for use in step (b) and a regeneration off-gas enriched in ammonia, withdrawing regeneration off-gas enriched in ammonia from the sorption vessel (9), and introducing it into the gasification reactor (2).

**FIG.1****EP 0 661 375 A1**

The present invention relates to a process of removing nitrogen compounds, such as hydrogen cyanide and ammonia from synthesis gas obtained from partially oxidizing in a gasification reactor a feed selected from the group including coal, oil, petroleum coke or natural gas.

It is known to remove hydrogen cyanide from a synthesis gas by hydrolyzing hydrogen cyanide in the presence of water to ammonia and carbon monoxide. Such a process is described in UK patent specification No. 2,159,132. This publication discloses that the hydrolysis of hydrogen cyanide is carried out at a temperature in the range of from 200 to 500 °C in the presence of a hydrolysis catalyst in the form of a titania-containing catalyst.

This publication, however, is silent about removing the ammonia from the synthesis gas having an increased ammonia content obtained after hydrolysis of hydrogen cyanide.

It is an object of the present invention to provide a simple process to remove nitrogen compounds from the gas obtained after hydrolysis of hydrogen cyanide.

To this end the present invention provides a process of removing hydrogen cyanide and ammonia from synthesis gas obtained from partially oxidizing in a gasification reactor a feed selected from the group including coal, oil or natural gas comprising the steps of:

- (a) supplying the synthesis gas in the presence of water to a reactor containing hydrolysis catalyst and withdrawing from the reactor a synthesis gas having an increased ammonia content;
- (b) contacting the synthesis gas having an increased ammonia content in a sorption vessel with regenerable sorption material to obtain ammonia-loaded sorption material and treated synthesis gas having a reduced ammonia content, and withdrawing treated synthesis gas from the sorption vessel; and
- (c) regenerating loaded sorption material to produce regenerated sorption material for use in step (b) and a regeneration off-gas enriched in ammonia, and introducing regeneration off-gas from the sorption vessel into the gasification reactor.

Although in the gasification reactor ammonia is formed, feeding ammonia to the gasification reactor does not result in an increase of the concentration of ammonia in the gaseous mixture leaving gasification reactor, see UK patent application publication No. 2 177 110. It is believed that the ammonia formed in the gasification reactor originates from nitrogen atoms in the feed, that ammonia supplied to the gasification reactor is converted to molecular nitrogen and water, and that the molecular nitrogen is inert.

The invention further relates to regenerating the hydrolysis catalyst; to this end the supply of synthesis gas in the presence of water to the reactor containing the hydrolysis catalyst is interrupted, and the hydrolysis catalyst is contacted with a gas which is free from nitrogen compounds.

The invention will now be described by way of example in more detail with reference to the accompanying drawings, wherein

Fig. 1 shows schematically the process line-up for the present invention;

Fig. 2 shows schematically an alternative line-up for the adsorption part of the process of the present invention; and

Fig. 3 shows schematically an alternative adsorption method.

Reference is now made to Fig. 1. A feed selected from the group including coal, hydrocarbon oil, petroleum coke or natural gas is supplied through a conduit 1 to a gasification reactor 2. In the gasification reactor 2 the feed is partially oxidized to produce a gaseous mixture including carbon monoxide and hydrogen. The oxidant can be steam or a free oxygen-containing gas such as oxygen, air, or oxygen enriched air, and it is supplied into the gasification reactor 2 via a conduit 3. The conditions in the gasification reactor are known to those skilled in the art and will not be discussed here in detail.

In the specification the gaseous mixture including carbon monoxide and hydrogen is referred to as raw synthesis gas.

Raw synthesis gas leaves the gasification reactor 2 through a conduit 4. This raw synthesis gas contains several contaminants, of these contaminants are relevant to the present invention nitrogen compounds in the form of hydrogen cyanide and ammonia. The other contaminants, such as ash and sulphur compounds, are removed in any manner suitable for the purpose; as the removal of these contaminants is not relevant to the present invention it will not further be discussed in detail.

To remove hydrogen cyanide, the raw synthesis gas is contacted in a reactor 5 in the presence of water with a suitable catalyst. In the reactor 5 hydrogen cyanide is catalytically hydrolysed to carbon monoxide and ammonia. It will be appreciated that the conditions in the hydrolysis reactor are known to those skilled in the art and will therefore not be discussed here in more detail. An example of a suitable hydrolysis catalyst is a titania-containing catalyst as described in UK patent specification No. 2 159 132. Water is supplied to the raw synthesis gas through a conduit 6.

From the reactor 5 synthesis gas having an increased ammonia content is withdrawn; this gas has a reduced hydrogen cyanide content.

The synthesis gas having an increased ammonia content is passed through a conduit 7 via an open valve 8 to a sorption vessel 9. The sorption vessel 9 contains regenerable sorption material for ammonia. The sorption material in the sorption vessel 9 is an adsorbent in the form of adsorbent particles. It will be appreciated that the adsorbent is known in the art and the kind of adsorbent is not relevant to the present invention. A suitable adsorbent is a molecular sieve.

In the sorption vessel 9 the synthesis gas having an increased ammonia content is contacted with the adsorbent particles to obtain ammonia-loaded adsorbent particles and purified synthesis gas having a reduced ammonia content. The purified synthesis gas is withdrawn from the sorption vessel 9 through a conduit 11, and via an open valve 12 the purified synthesis gas is passed through a conduit 13 away for any further treatment suitable for the purpose.

The loaded adsorbent particles are regenerated in the following way. At first the valve 8 is closed to interrupt contacting the synthesis gas having an increased ammonia content with the adsorbent particles in the sorption vessel 9, and the valve 12 is closed to prevent gas from flowing into the conduit 13. Thereafter a valve 15 in a conduit 16 is opened to supply regeneration gas in the form of synthesis gas to the sorption vessel 9. Loaded adsorbent particles in the sorption vessel 9 are contacted with the regeneration gas to obtain regenerated adsorbent particles and regeneration off-gas containing desorbed ammonia. This regeneration off-gas is passed via an open valve 19 through a conduit 20, and it is introduced into the gasification reactor 2. After the regeneration has been completed the valves 15 and 19 are closed and the valves 8 and 12 are opened so that synthesis gas having an increased ammonia content is contacted with the regenerated adsorbent particles in the sorption vessel 9. The concentration of nitrogen compounds in the regeneration gas should be such that during regeneration ammonia desorbs from the loaded adsorbent particles.

Reference is now made to Fig. 2 showing schematically an alternative line-up for the adsorption part of Fig. 1, wherein the adsorption part comprises two sorption vessels 29 and 29' each filled with adsorbent particles. The use of two sorption vessels allows a continuous and cyclic operation wherein each cycle comprises adsorption in the first sorption vessel 29 and simultaneously regenerating the adsorbent particles in the second sorption vessel 29', followed by adsorption in the second sorption vessel 29' and simultaneously regenerating the adsorbent particles in the first sorption vessel 29.

During normal operation synthesis gas is produced in the gasification reactor 2 and hydrogen cyanide is hydrolyzed in the reactor 5 to obtain synthesis gas having an increased ammonia content as described with reference to Fig. 1.

Synthesis gas having an increased ammonia content is supplied through the conduit 7 via an open valve 28 to the first sorption vessel 29 in which it is contacted with the adsorbent particles to obtain ammonia-loaded adsorbent particles and treated synthesis gas. Treated synthesis gas is withdrawn from the first sorption vessel 29 via an open valve 32 and the conduit 13. The adsorbent particles in the second sorption vessel 29' are contacted with a regeneration gas supplied to it through a conduit 16' from the conduit 13 via an open valve 35' to obtain regenerated adsorbent particles and regeneration off-gas enriched in ammonia. The regeneration off-gas is supplied to the gasification reactor via an open valve 39' and the conduit 20. The valves 28' and 32' and the valves 35 and 39 are closed. The valve 15' controls the flowrate of regeneration gas through the conduit 16'.

Once the regeneration of the adsorbent particles in the second sorption vessel 29' is completed and the adsorbent particles in the first sorption vessel 29 are loaded to a predetermined level, the adsorbent particles in the first sorption vessel 29 will be regenerated and the second sorption vessel 29' will be used to remove ammonia. To this end the valves 28 and 32 and the valves 35' and 39' are closed to interrupt contacting the synthesis gas having an increased ammonia content with the adsorbent particles in the first sorption vessel 29, and to interrupt contacting the adsorbent particles in the second sorption vessel 29' with the regeneration gas. Subsequently synthesis gas having an increased ammonia content is supplied through the conduit 7 via the open valve 28' to the second sorption vessel 29' in which it is contacted with the adsorbent particles to obtain ammonia-loaded adsorbent and treated synthesis gas. Treated synthesis gas is withdrawn from the second sorption vessel 29' via the open valve 32' and the conduit 13. The adsorbent particles in the first sorption vessel 29 are contacted with a regeneration gas supplied to it through the conduit 16 and the open valve 35 to obtain regenerated adsorbent and regeneration off-gas enriched in ammonia. The regeneration off-gas is supplied to the gasification reactor via the open valve 39 and the conduit 20.

Once the regeneration of the adsorbent particles in the first sorption vessel 29 is completed and the adsorbent particles in the second sorption vessel 29' are loaded to a predetermined level, the adsorbent particles in the second sorption vessel 29' are regenerated and the first sorption vessel 29

is used to remove ammonia. To this end the valves 28' and 32' and the valves 35 and 39 are closed to interrupt contacting the synthesis gas having an increased ammonia content with the adsorbent particles in the second sorption vessel 29', and to interrupt contacting the adsorbent particles in the first sorption vessel 29 with the regeneration gas.

Ammonia may also be removed from the synthesis gas having an increased ammonia content leaving the reactor 5 using a sorption material in the form of a liquid and regenerable absorbent such as water. A line-up of this alternative to the above described adsorption is shown schematically in Fig. 3. The synthesis gas having an increased ammonia content from the reactor (5 in Fig. 1) is passed through the conduit 7 to a sorption vessel in the form of an absorber 41. In the absorber 41 it is counter-currently contacted with lean regenerable absorbent supplied to the absorber 41 through a conduit 43. Purified synthesis gas leaves the absorber 41 through the conduit 13. Loaded absorbent leaves the absorber 41 through a conduit 45, and it is passed to a regenerator 48, where loaded absorbent is regenerated by stripping the loaded absorbent with regeneration gas supplied through a conduit 49, a suitable regeneration gas is steam. Regeneration off-gas containing the removed ammonia is withdrawn through a conduit 50 and passed to the gasification reactor (2 in Fig. 1), and regenerated absorbent is supplied through a conduit 43 to the absorber 41.

A further aspect of the present invention relates to regenerating the hydrolysis catalyst. With time the activity of the hydrolysis catalyst in the reactor 5 (see Fig. 1) decreases, therefore the hydrolysis catalyst has to be regenerated. Regenerating the hydrolysis catalyst is done by interrupting supplying the synthesis gas in the presence of water to the reactor 5 which contains the hydrolysis catalyst, and contacting the hydrolysis catalyst with a gas which is free from nitrogen compounds.

For continuous operation there are provided two catalytic reactors, one being used to hydrolyze hydrogen cyanide and the other being regenerated. The gas free from nitrogen compounds is suitably a slip stream of the purified gas and the off-gas from the regeneration can be supplied into the gasification reactor.

In conclusion the present invention provides a simple process to remove nitrogen compounds from synthesis gas by hydrolyzing the nitrogen compounds and by removing ammonia from the gas stream obtained after hydrolysis.

Various modifications of the present invention will become apparent to those skilled in the art from the foregoing description. Such modifications are intended to fall within the scope of the appended claims.

## Claims

1. A process of removing hydrogen cyanide and ammonia from synthesis gas obtained from partially oxidizing in a gasification reactor a feed selected from the group including coal, oil or natural gas comprising the steps of:
  - (a) supplying the synthesis gas in the presence of water to a reactor containing hydrolysis catalyst and withdrawing from the reactor a synthesis gas having an increased ammonia content;
  - (b) contacting the synthesis gas having an increased ammonia content in a sorption vessel with regenerable sorption material to obtain ammonia-loaded sorption material and treated synthesis gas having a reduced ammonia content, and withdrawing treated synthesis gas from the sorption vessel; and
  - (c) regenerating loaded sorption material to produce regenerated sorption material for use in step (b) and a regeneration off-gas enriched in ammonia, and introducing regeneration off-gas from the sorption vessel into the gasification reactor.
2. The process as claimed in claim 1, wherein the regenerable sorption material consists of adsorbent arranged in the sorption vessel, and wherein regenerating loaded sorption material comprises interrupting contacting the synthesis gas having an increased ammonia content with the adsorbent; contacting the adsorbent with a regeneration gas to obtain regenerated adsorbent and regeneration off-gas enriched in ammonia which is introduced into the gasification reactor; and interrupting contacting the adsorbent with the regeneration gas.
3. The process as claimed in claim 1, wherein use is made of two sorption vessels containing adsorbent, and wherein the steps of contacting the synthesis gas having an increased ammonia content with sorption material and regenerating loaded sorption material comprise:
  - (i) contacting the synthesis gas having an increased ammonia content in the first sorption vessel with the adsorbent to obtain ammonia-loaded adsorbent and treated synthesis gas, withdrawing treated synthesis gas from the first sorption vessel, and contacting the adsorbent in the second sorption vessel with a regeneration gas to obtain regenerated adsorbent and regeneration off-gas enriched in ammonia which is introduced into the gasification reactor;
  - (j) interrupting contacting the synthesis gas having an increased ammonia content with

th adsorbent in th first sorption vessel,  
and interrupting contacting th adsorbent in  
th second sorption vessel with th reg n-  
eration gas;

(k) contacting the adsorbent in the first 5  
sorption vessel with a regeneration gas to  
obtain regenerated adsorbent and regenera-  
tion off-gas enriched in ammonia which is  
introduced into the gasification reactor, and  
contacting the synthesis gas having an in- 10  
creased ammonia content in the second  
sorption vessel with adsorbent to obtain am-  
monia-loaded adsorbent and treated synthe-  
sis gas;

(l) interrupting contacting the adsorbent in 15  
the first sorption vessel with the regenera-  
tion gas, and interrupting contacting the  
synthesis gas having an increased ammonia  
content with the adsorbent in the second  
sorption vessel; and 20

(m) continuing with step (i).

4. The process as claimed in claim 1, wherein the 25  
regenerable sorption material is a liquid absor-  
bent, and wherein regenerating loaded liquid  
absorbent comprises stripping the loaded ab-  
sorbent with a regeneration gas.
5. The process as claimed in any one of the 30  
claims 1-4, further comprising regenerating the  
hydrolysis catalyst by interrupting supplying  
the synthesis gas in the presence of water to  
the reactor containing the hydrolysis catalyst,  
and contacting the hydrolysis catalyst with a 35  
gas which is free from nitrogen compounds.

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FIG.1

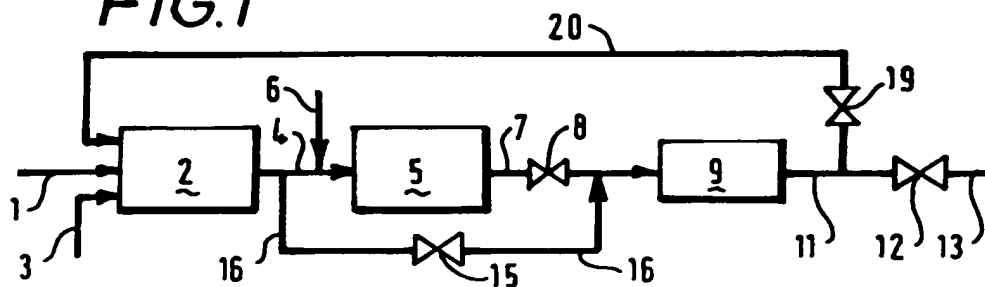


FIG.2

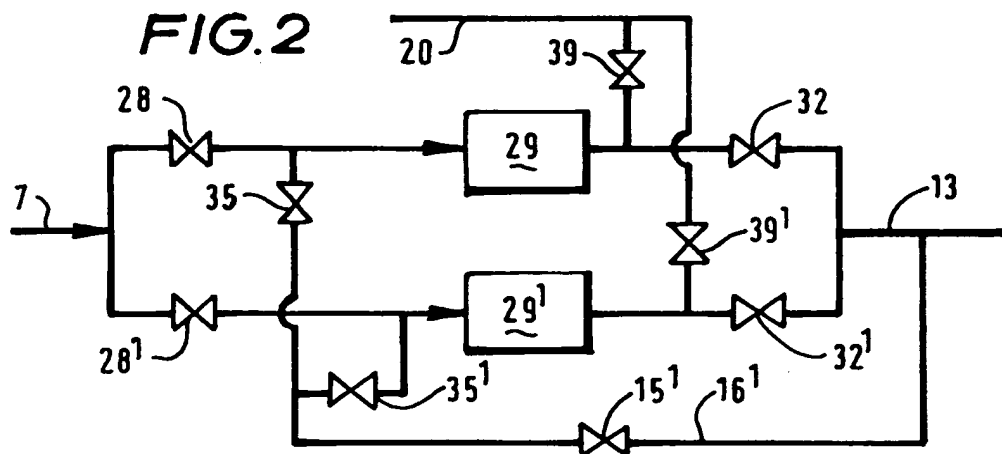
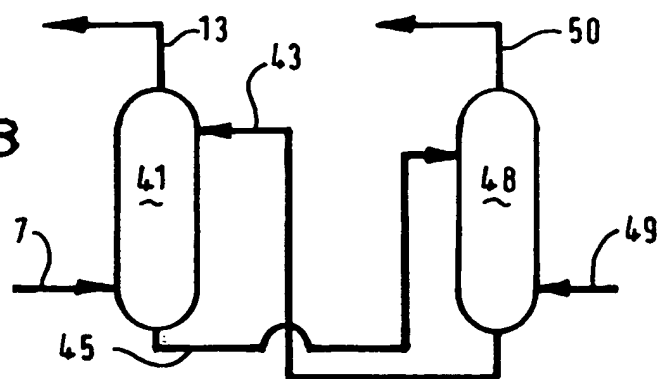


FIG.3





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## EUROPEAN SEARCH REPORT

Application Number  
EP 94 20 3780

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. CL.6)
Y	US-A-5 112 586 (BAKER)	1-3	C10K1/34
A	* column 5, line 3 - line 54 * * column 6, line 3 - line 49; figure * ---	4	C10K1/20 C10K1/10 C01B3/54
Y	DATABASE WPI Derwent Publications Ltd., London, GB; AN 91-356995 & JP-A-03 238 019 (DENRYOKU CHUO LAB) , 23 October 1991 * figure * * abstract * ---	1,2	
Y	GB-A-2 180 848 (SHELL INTERNATIONALE RESEARCH MAATSCHAPPIJ) * claims 1,2; figure * ---	3	
A	EP-A-0 487 158 (SHELL INTERNATIONALE RESEARCH MAATSCHAPPIJ) * claims 1,5 * ---	1,5	
A	US-A-2 837 398 (GROSSKINSKY ET AL.) * claim 1 * -----	1,2,4	TECHNICAL FIELDS SEARCHED (Int. CL.6)  C10K C01B B01D
The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>24 April 1995</b>	Examiner <b>Cubas Alcaraz, J</b>
<b>CATEGORY OF CITED DOCUMENTS</b> X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document  T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- A : member of the same patent family, corresponding document			